

Work Order ID 82947

82947

Page 1

Wednesday, April 11, 2012 12:53:40 PM

Item ID: D2873-045 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Nut Plate Assembly
 Start Date: 4/11/2012 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 4/27/2012 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: *R* Date: 12-04-11 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2873	Rev A

100 0.00
100 BAND SAW
 Bandsaw Memo 0.00 *F.K 12/04/14* 40 *8*
 Jeaspa Bandsaw Cut blanks: 1.000" x 0.375" x 2.700" long

110 0.00
110 HAAS CNC VERTICAL MACHINING #1
 HAAS 1 Memo 0.00 *B.A 12/04/18* 40 *8*
 HAAS CNC vertical machine #1 Machine as per Folio FA and Dwg D2873 Identify as D2873-5
 Dwg Rev A F1819 Folio Rev AA

120 0.00
120 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00 *B.A 12/04/18* 40 *8*
 Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	SL	12/04/20					
140 *140* Small Fab Small Fab	Small Fab Memo 1-Deburr 2- C'sink as per Dwg D2873	0.00 0.00				40	Ø		12/04/23
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		Scrub/23		(Cuts) x40			

W/O:		WORK ORDER CHANGES					
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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QS1005 4.1	0.00							
160						40.	φ	12-4-24	
HandFinish	Memo	0.00							
Hand Finishing									
170	QC3- Inspect Part Finish	0.00							
170						40x	φ	12-4-24	
QC	Memo	0.00							
Quality Control									
180		0.00							
180	Small Fab					40	φ	12/04/25	
Small Fab	Memo	0.00							
Small Fab	1-Assemble as per Dwg D2873 2-Identify as D2873-045								

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Nut Plate Assembly

Start Date: 4/11/2012 **Start Qty:** 20.00

20

Cust Item ID:

Required Date: 4/27/2012 **Req'd Qty:** 20.00

20

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

190

0.00 81764125

QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: LG 52

0.00

200

Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

112-04-25

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, April 11, 2012 12:53:45 PM

Page 1

Work Order ID: 82947

82947

Parent Item: D2873-045

D2873-045

Parent Item Name: Nut Plate Assembly

Start Date: 4/11/2012

Required Date: 4/27/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A05.09.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS21075L5

Purchased

No

100

Each

26.0000

2

40

MS21075L5

**

Nut Plate

Location

Loc Qty

Loc Code

ST304

26

121162

26

M6061T6B0.375X01.00

Purchased

No

180

f

35.8120

0.225

4.736842

M6061T6B0 375X01 000

**

6061T6 BAR .375 x 1.00

Location

Loc Qty

Loc Code

MAT001

2.292

118641

2.292

MAT002

33.52

119346

12

120603

0.76

120866

0.76

121192

20

MS20426AD4-6

Purchased

No

180

Each

1,514.000

4

80

MS20426AD4-6

**

Rivet

Location

Loc Qty

Loc Code

ST317

1514

110139

187

118510

653

119436

674

SP 12/04/25
M121444 (80x)

FK 12/04/14

7735 9:474

SP 12/04/25

160

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	82947
Description: Radius Block		Part Number:	D2873-5
Inspection Dwg: D2873 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	+/-0.030	2.503	✓		Vern	GA-01
1.000	+/-0.010	1.000	✓		"	"
0.750	+/-0.010	0.751	✓		"	"
0.250	+/-0.010	0.251	✓		"	"
1.000	+/-0.010	1.000	✓		"	"
2.000	+/-0.010	2.000	✓		"	"
Ø0.128	+0.005/-0.001	Ø0.132	✓		"	"
0.359	+/-0.010	0.359	✓		"	"
Ø0.316	+0.006/-0.001	Ø0.317	✓		"	"
1.000	+/-0.010	1.000	✓		"	"
0.250	+/-0.010	0.251	✓		"	"
0.061	+/-0.010	0.064	✓		"	"
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	Ø0.231 x 0.124	✓		"	"

Measured by:	BA	Audited by:	JL	Prototype Approval:	N/A
Date:	12/04/18	Date:	12-04-20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-045	KJ/JLM	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

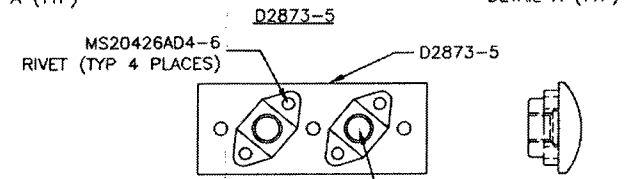
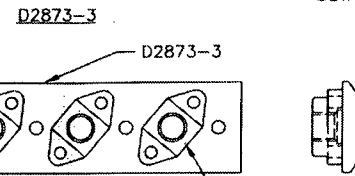
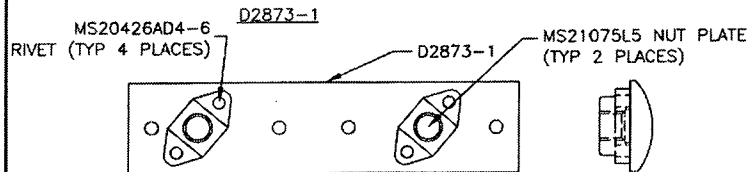
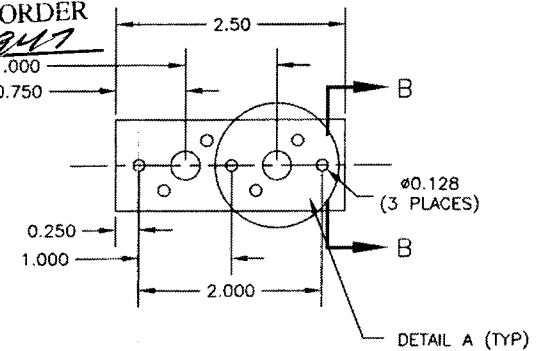
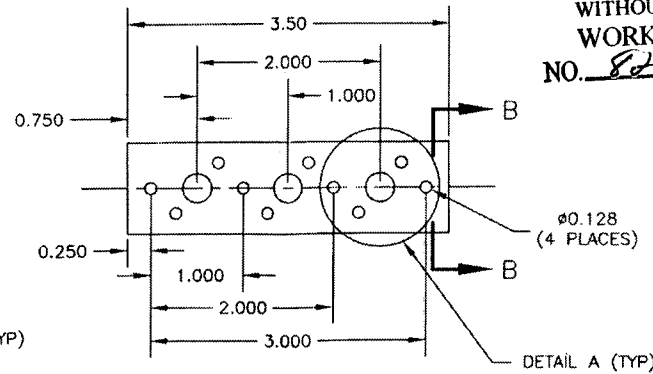
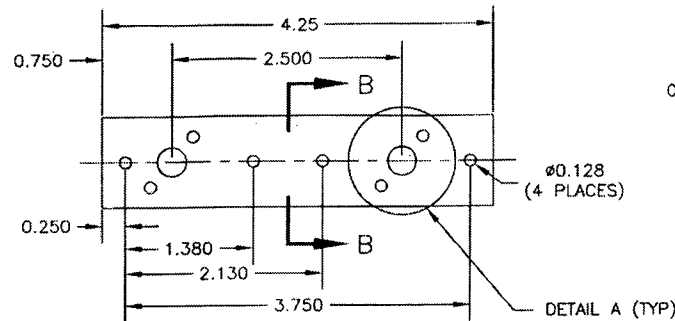
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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

10-04-11

WITHOUT NOTICE
WORK ORDER
NO. 82947



D2873-041

MS20426AD4-6
RIVET (TYP 6 PLACES)

D2873-043

MS21075L5 NUT PLATE
(TYP 3 PLACES)

D2873-045

MS21075L5 NUT PLATE
(TYP 2 PLACES)

D2873-1/-3/-5 RADIUS BLOCK

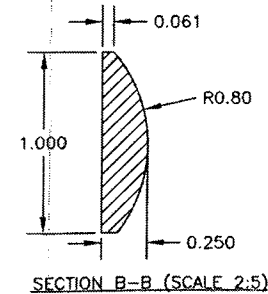
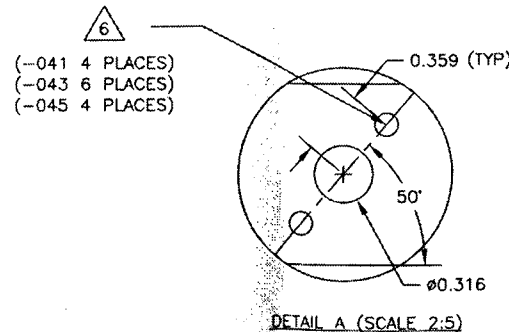
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X00.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X00.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) $\varnothing 0.128$ PILOT + C'BORE CURVED SIDE $\varnothing 0.230 \times 0.125$ DEEP + C'SINK CURVED SIDE $\varnothing 0.225 \times 100^\circ$

D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



RELEASED
05-07-26

A	05.07.26	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED DS	APPROVED DS	DART
DATE	05.07.26	DRAWING NO. D2873
		TITLE RADIUS BLOCK
		REV. A
		SHEET 1 OF 1
		SCALE 4:5

Dart Aerospace Ltd

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